

Date: Tuesday, 4/4/2006 1:36:39 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : T-BEAM EXTRUSION
Job Number : 26538	
Estimate Number : 10043	
P.O. Number : SEE N/A	Part Number : D6201
This Issue : 4/4/2006 S.O. No. : N/A	Drawing Number : D6201 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/14/2006 Qty: 20 Um: Each
Checked & Approved By : <u>06.04.04</u>	
Comment : Est. A: 01.05.15 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 455

a) Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f) Material certification required

oh C 206104104 (20)

C. 206104104

2.0	D6201P	T Extrusion 4X4X3/8
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Comment: Qty.: 1.0000 f(s)/Unit Total : 20.0000 f(s)
 T Extrusion 4X4X3/8

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

P 06/4/11 (1) 20

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6104

11 06.04.17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/01/17

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:36:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: T-BEAM EXTRUSION

Job Number: 26538

Part Number: D6201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

u 06-04-17 (20)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/04/17 (20)

Job Completion



u 06-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

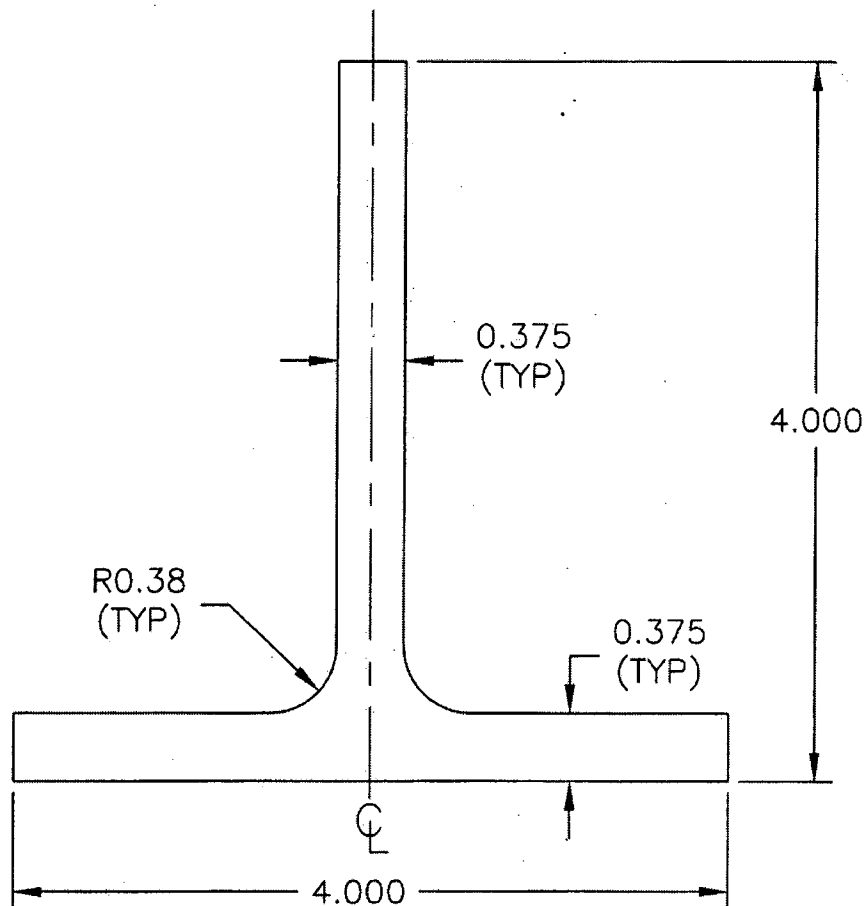
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26538*

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KAISER ALUMINUM
MATERIAL CERTIFICATION

KAISER ALUMINUM
EXTRUDED PRODUCTS DIVISION
3021 GORE ROAD
LONDON ON NSV 5A9

PAGE 1

SOLD TO		PURCHASE ORDER	03/08/06 DATE PRINTED
V872002	TER 4.000X4.000X.375		
CUSTOMER PART NUMBER	DESCRIPTION		
719817-002	C9428 135	6061-T6	
RELEASE-ITEM	LOT	ALLOY/TEMPER	

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
C9428 135	0001 1	45.0	41.8	11.3	RE 94	N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
6061 LIMITS												
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	Ea Tot
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA	

APPLICABLE REQUIREMENTS:

ASTM-B308-02-STENCILED
EXCEPT HARDNESS TESTED PER
C=0,1.5 AQL SAMPLING PLAN
ASTM-B221-05A, AMS-QQ-A-200/8
AMS-QQ-A-200/16 UNS#96061
ASME-SB221 1998 SECT II

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

DART**Purchase Order**

Date Apr 06, 2006	Page 1
Purchase Order Number PO00000955	

1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Phone: (813)832-8577
Fax: (813)832-1063

Vendor Address:

Metaux Solutions
2108, 32e Avenue
Lachine, QC H8T 3H7
Phone (800) 558-8858
Fax (514) 633-8044

FAKED
06/10/10

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MET002	Apr 06, 2006	N30	PREPAID	Apr 14, 2006

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
20.0000	D6201P	T Extrusion 4X4X3/8 Comments: a) DESCRIPTION: T-BEAM EXTRUSION B) 4.00" X4.00 " X0.375" PER DWG D6201 REV A C) MINIMUM ULTIMATE TENSILE STRENGTH=38KSI D) MINIMUM YIELD TENSILE STRENGTH =35KSI E) MATERIAL: 6061-T6/T6511 (Q2-A-20048) F) MATERIAL CERTIFICATION REQUIRED	4/14/2006	No	14.500000		290.00
<p>Please send cart for P.O. 955 ASAP CY</p>							
Comments:			20.30	Less:			
GST			0.00	included tax		0.00	
GSTME			0.00	Subtotal		290.00	
GSTND			0.00	Total tax		20.30	
Entered By: CY			APPROVEN		Total purchase order in		
Approved By: <u>W. [Signature]</u>					CAD Dollars		310.30